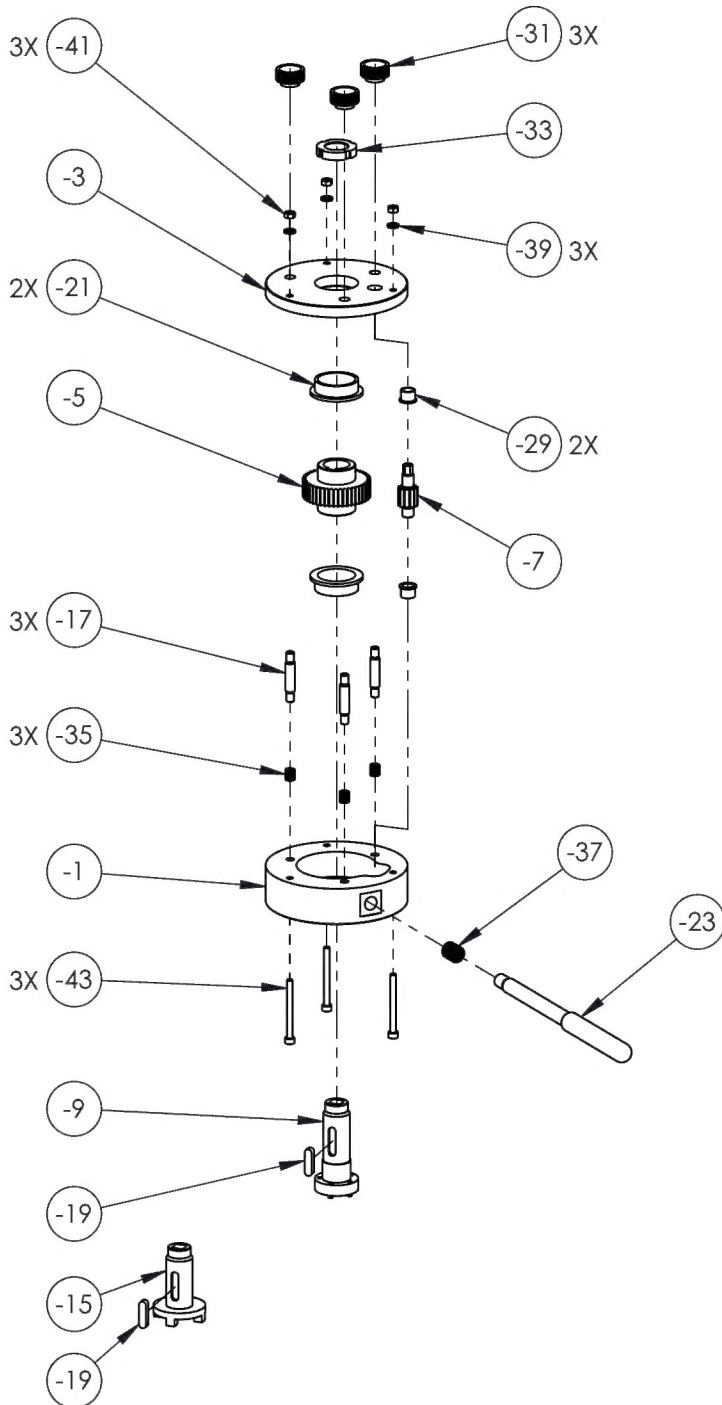
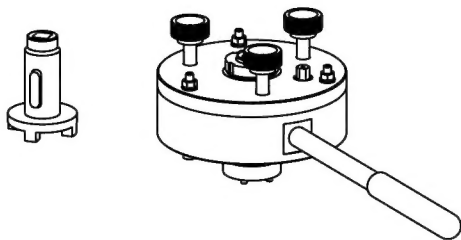


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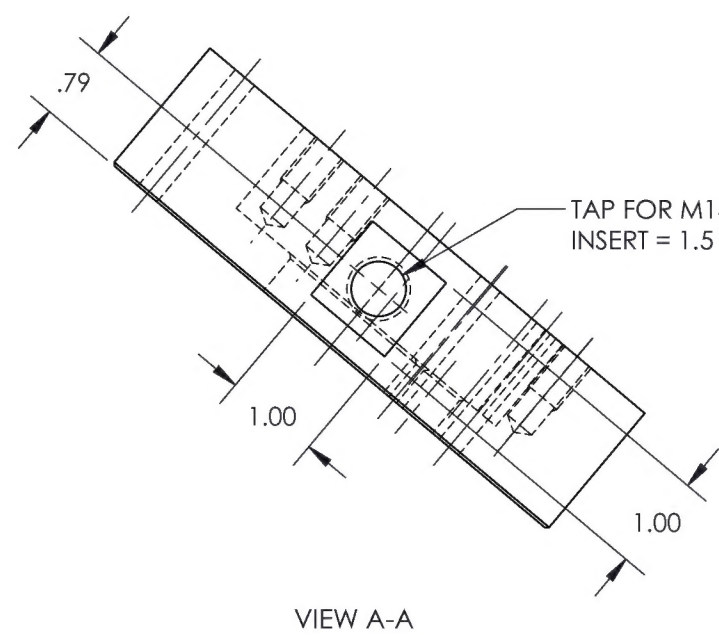
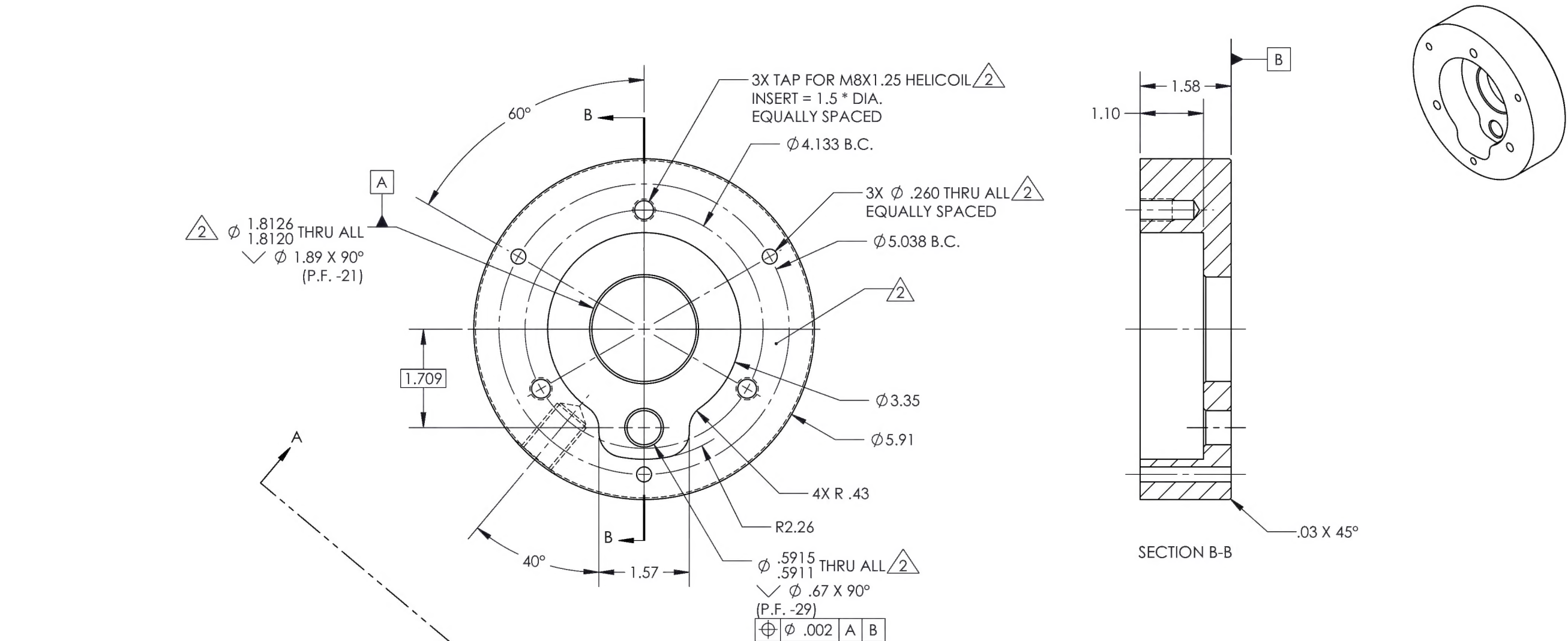
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/29/2016	DPD	JAG
2	17-0006	-5, -7, -11, -15 CH'D MATERIAL WAS 4140/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. -11, -15 CH'D DIM WAS .317/.315 IS .318/.316 (S.F. -19). -13 ADDED DIMS Ø.3140/.3135, .08. -19 CH'D QTY. WAS 1 IS 2. CH'D FINISH WAS QMSI-6.2.2 REV D IS QMSI-6.2.2, B.O. REV D. -23 CH'D ENGRAVE NOTE WAS INK STAMP "RBEM653V3005121-23" IS LASER ENGRAVE "RBEM653V3005121-23". -25 CH'D DIM WAS Ø.63 IS Ø.62.	4/14/2017	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	HOUSING PLATE	6061		2
			-3	1	COVER PLATE	6061		3
			-5	1	46 TOOTH GEAR	4140/4142		4
			-7	1	12 TOOTH GEAR	4140/4142		5
	X		-9	1	WRENCH HEAD ASSEMBLY			6
	1		-11		WRENCH HEAD	4140/4142		7
	5		-13		WRENCH HEAD PIN	O-1		8
			-15	1	LOCK SCREW WRENCH HEAD	4140/4142		9
			-17	3	THREADED ROD	4140/4142		10
			-19	2	KEY	STEEL	7mm X 8mm (MCMaster-CARR #92288A740) MODIFIED	11
			-21	2	FLANGED SLEEVE BEARING	SAE 660	Ø40mm I.D. X Ø46mm O.D. X 20mm (MCMaster-CARR #5448T29) MODIFIED	12
X			-23	1	HANDLE ASSEMBLY			13
1			-25		HANDLE	4140/4142		14
1		B/O	-27		HANDLE GRIP	BLACK VINYL	Ø5/8 I.D. X 4-7/8 (MCMaster-CARR #97065K38)	13
		B/O	-29	2	FLANGED SLEEVE BEARING	SAE 841	Ø12mm I.D. X 15mm O.D. X 12mm (SYMMCO #5FM-12X15X12X18X1.5)	1
		B/O	-31	3	KNURLED NUT	STEEL	M8 X 1.25mm (J.W. WINCO #8NF45/A)	1
		B/O	-33	1	SPANNER NUT	STEEL	M24 X 1.5mm (J.W. WINCO #240XSNB)	1
		B/O	-35	3	HELICAL INSERT	S.S.	M8 X 1.25mm X 12mm (MCMaster-CARR #91000A069)	1
		B/O	-37	1	HELICAL INSERT	S.S.	M14 X 2mm X 21mm (MCMaster-CARR #91732A671)	1
		B/O	-39	3	WASHER	STEEL	M6 (MCMaster-CARR #91166A250)	1
		B/O	-41	3	HEX NUT	STEEL	M6 X 1mm (MCMaster-CARR #90591A151)	1
		B/O	-43	3	SOCKET HEAD CAP SCREW	STEEL	M6 X 1mm X 65mm (MCMaster-CARR #91502A177)	1
ASSY -23	ASSY -9							

- NOTES:
1. REF. AIRBUS T/N: M653V3005121.
2. PART OF KIT RBEM653V3005101.
3. GREASE INTERNAL PARTS.

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:6	DATE 5/12/2016
SHEET 1 OF 14	

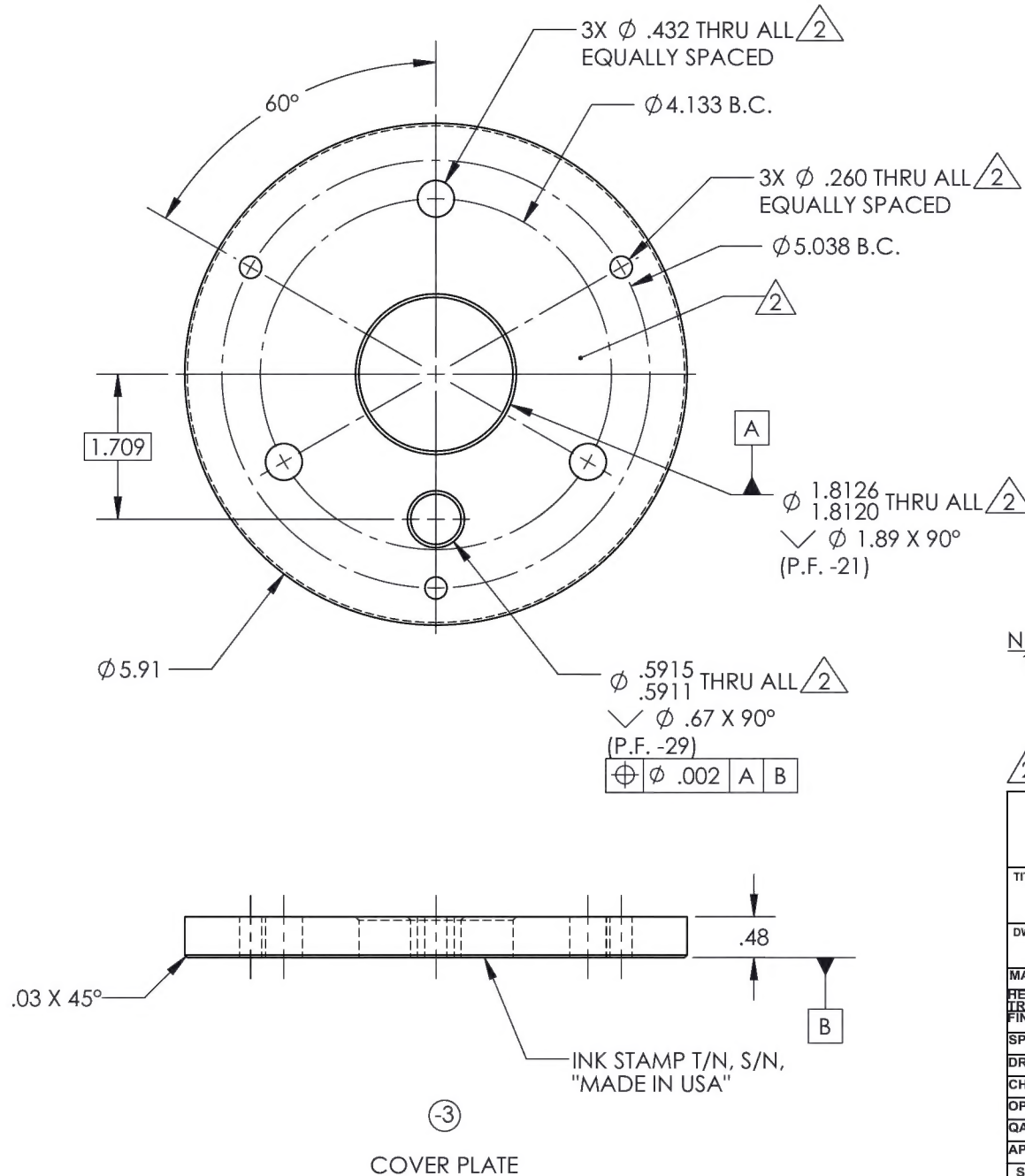


NOTES:
1. DUAL FINISH:
1ST: CLEAR ANODIZE,
MIL-A-8625F TYPE II CLASS I.
2ND: POWDER COAT YELLOW, FED #13538.
2 NO POWDER COAT THIS SURFACE.

DART AEROSPACE			
TITLE LABOR SAVING WRENCH			
DWG NO. RBEM653V3005121-1			REV 2
MAT'L 6061		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH SEE NOTE 1		.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .1 SURFACES = 125/	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		H175	
SCALE 1:2	DATE 5/12/2016	SHEET 2 OF 14	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	

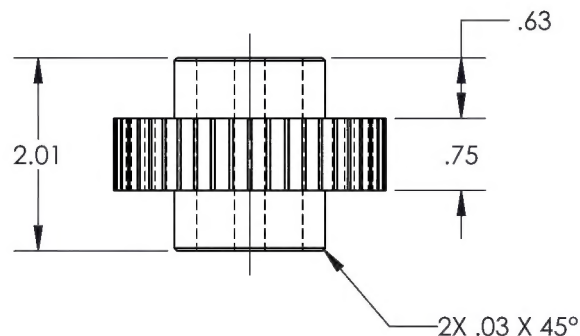
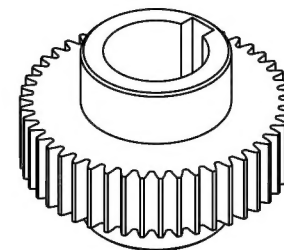
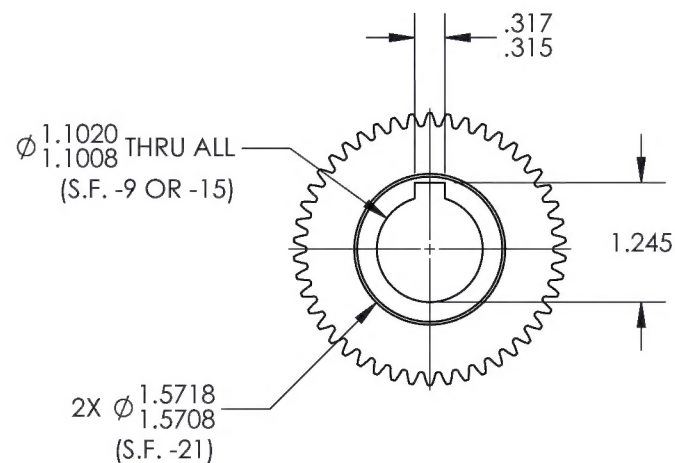


- NOTES:
- DUAL FINISH:
1ST: CLEAR ANODIZE,
MIL-A-8625F TYPE II CLASS I.
2ND: POWDER COAT YELLOW, FED #13538.
 - $\triangle 2$ NO POWDER COAT THIS SURFACE.

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-3	REV 2
MAT'L 6061 HEAT TREAT FINISH SEE NOTE 1 SPEC DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX \pm .005 FRACTIONS \pm 1/8 .XX \pm .01 ANGLES \pm 5° .X \pm .1 SURFACES = 125 \checkmark 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL H175	
SCALE 1:2	DATE 5/12/2016
SHEET 3 OF 14	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-5 CH'D MATERIAL WAS 4140/4142 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34.	4/14/20107	RJC	JAG



GEAR CUTTING DATA

No. OF TEETH	46
DIAMETRAL PITCH	16.943
PRESSURE ANGLE	20°
PITCH DIAMETER	2.715
MAJOR DIAMETER	2.833
MINOR DIAMETER	2.567
ADDENDUM	.059
CHORDAL TOOTH THICKNESS	.093
FILLET RADIUS	.023
MEASUREMENT OVER PINS	2.863
PIN DIAMETER	.107

(-5)

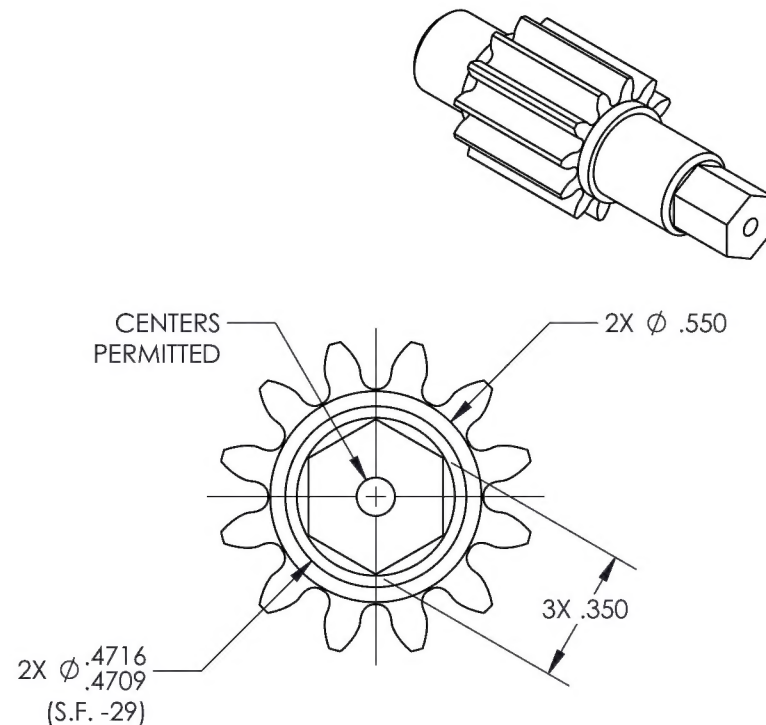
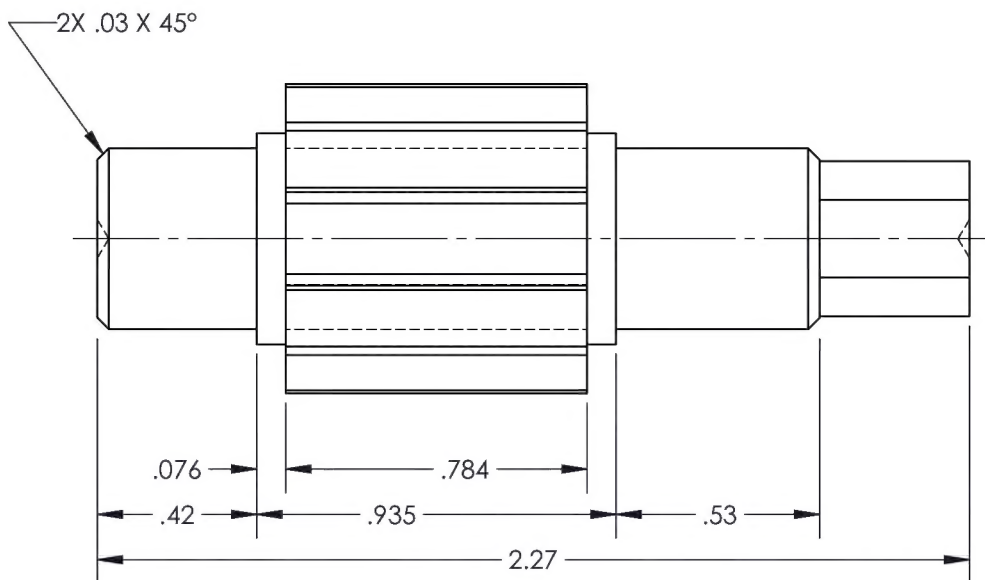
46 TOOTH GEAR



TITLE LABOR SAVING WRENCH		
DWG NO. RBEM653V3005121-5	REV 2	
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES	
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8	
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°	
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°	
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON	.015 x 45° OR .015R	
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT	AFTER PLATING	
SCALE 1:2	DATE 5/12/2016	SHEET 4 OF 14

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-7 CH'D MATERIAL WAS 4140/4142 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34.	4/14/2017	RJC	JAG



GEAR CUTTING DATA

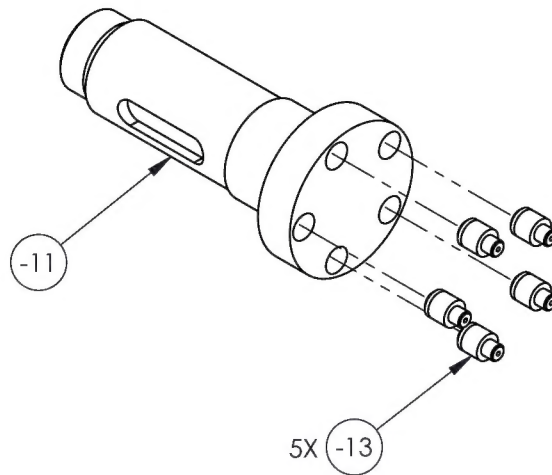
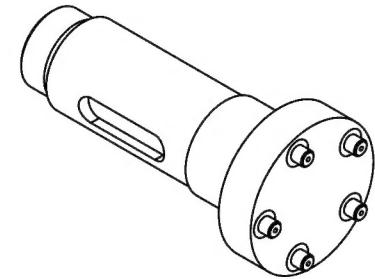
No. OF TEETH	12
DIAMETRAL PITCH	16.943
PRESSURE ANGLE	20°
PITCH DIAMETER	.708
MAJOR DIAMETER	.826
MINOR DIAMETER	.561
ADDENDUM	.059
CHORDAL TOOTH THICKNESS	.087
FILLET RADIUS	.023
MEASUREMENT OVER PINS	.852
PIN DIAMETER	.107

(-7)
12 TOOTH GEAR

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-7	REV 2
MAT'L 4140/4142 HEAT TREAT RC 28-34 FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 2:1	DATE 5/12/2016
SHEET 5 OF 14	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



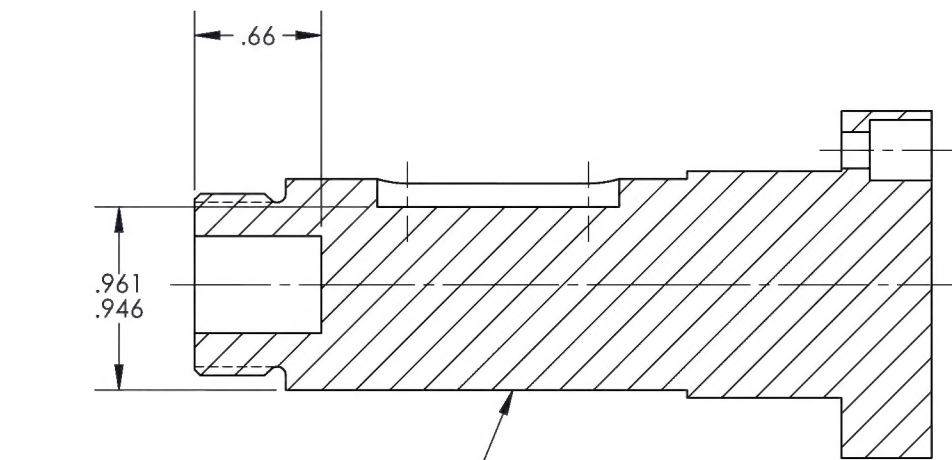
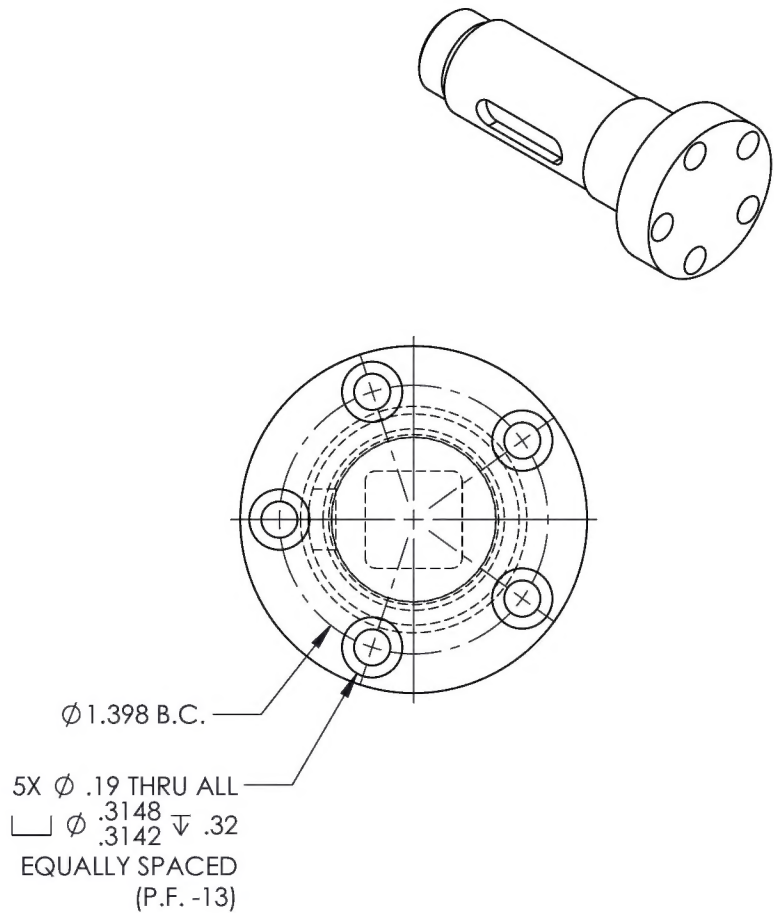
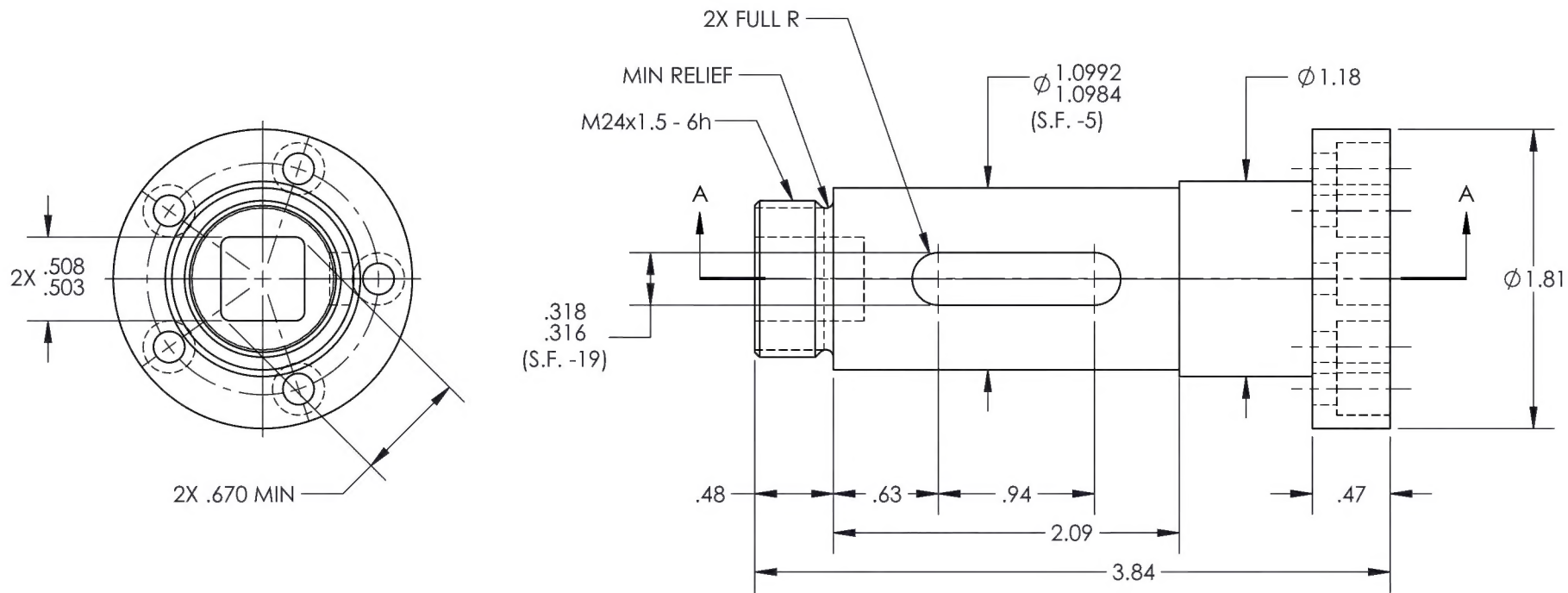
(-9)

WRENCH HEAD ASSEMBLY

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-9	REV 2
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 5/12/2016
SHEET 6 OF 14	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	17-0006	-11 CH'D DIM WAS .317/.315 IS .318/.316 (S.F. -19), CH'D MATERIAL WAS 4140/4142 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34.			4/14/2017	RJC	JAG



ENGRAVE "RBEM653V3005121-9"

SECTION A-A

-11

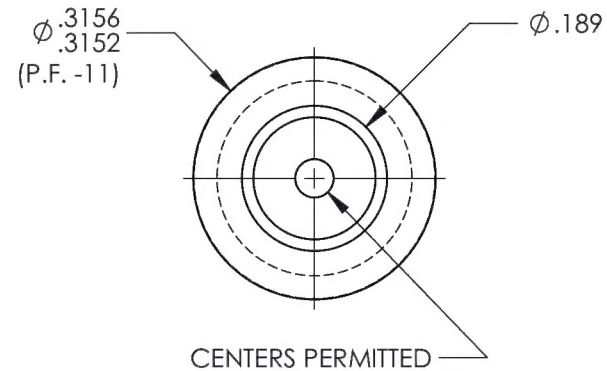
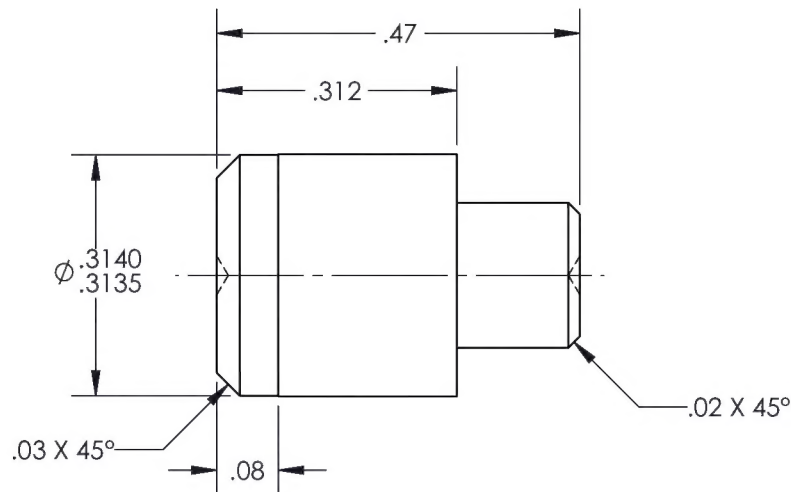
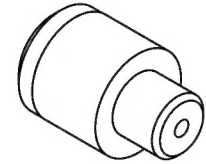
WRENCH HEAD

NOTE:
TIMING OF FEATURES NOT CRITICAL.

DART AEROSPACE			
TITLE LABOR SAVING WRENCH			
DWG NO. RBEM653V3005121-11			REV 2
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT RC 28-34		DIMENSIONS ARE IN INCHES	
FINISH SEE -9		.XXX $\pm .005$ FRACTIONS $\pm 1/8$	
SPEC		.XX $\pm .01$ ANGLES $\pm 5^\circ$	
DRAWN BY: DUERFELDT		.X $\pm .1$ SURFACES = 125	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 5/12/2016		USED ON MODEL	
SHEET 7 OF 14		H175	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-13 ADDED DIMS Ø.3140/.3135, .08.	4/14/2017	RJC	JAG



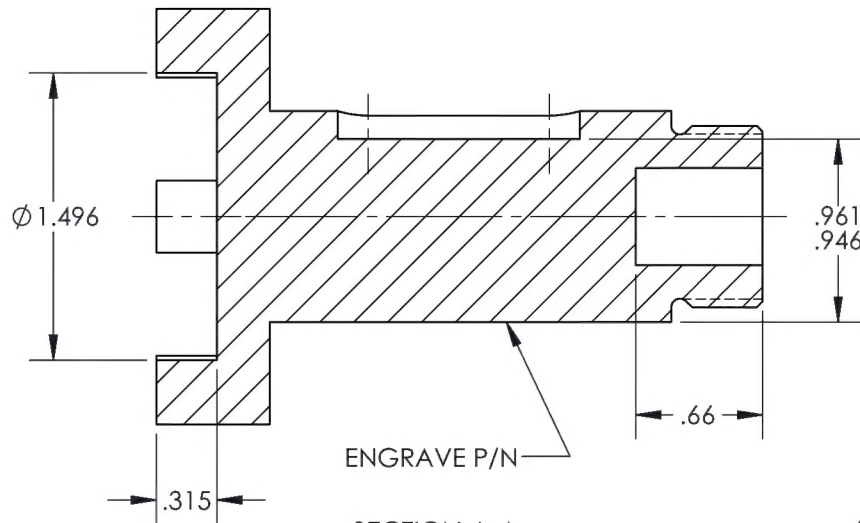
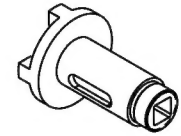
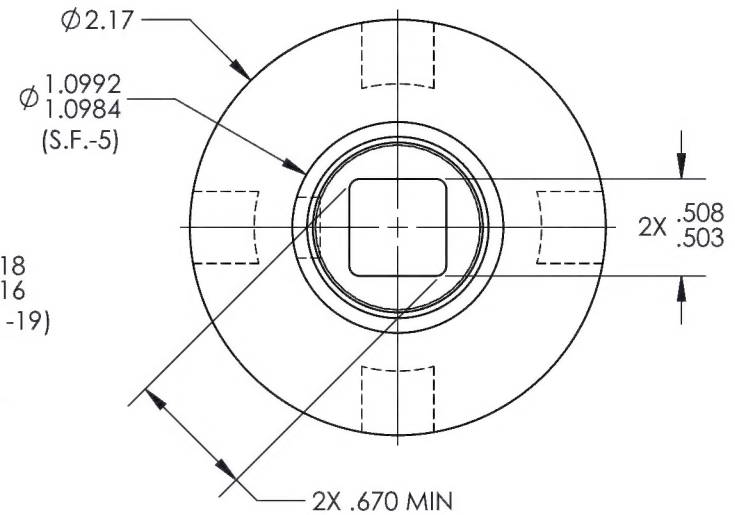
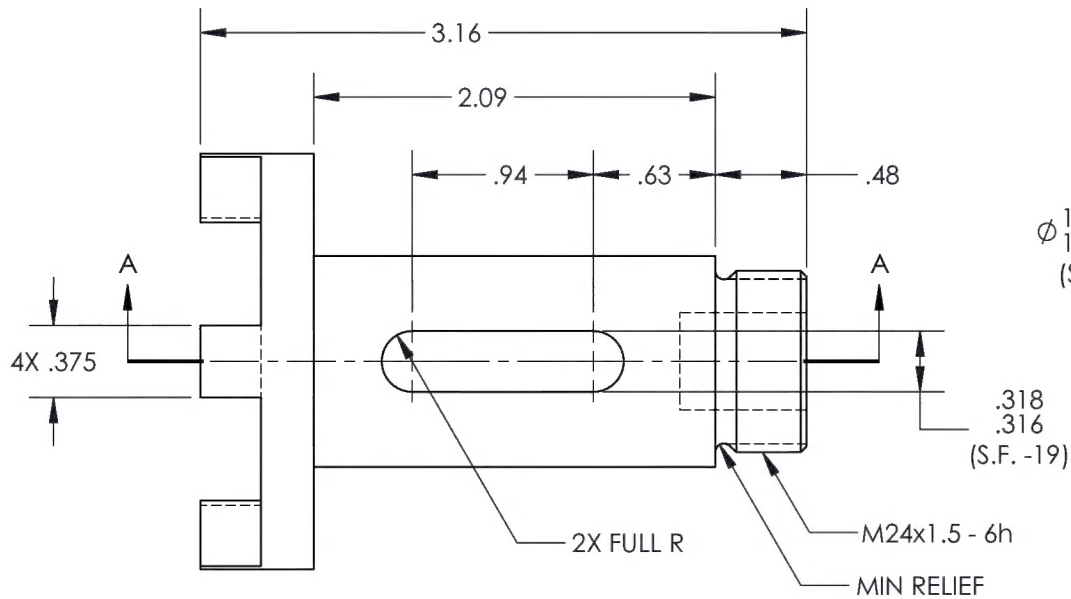
(-13)

WRENCH HEAD PIN

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-13	REV 2
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT RC 55-60	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -9	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 4:1	DATE 5/12/2016
	SHEET 8 OF 14

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-15 CH'D DIM WAS .317/.315 IS .318/.316 (S.F. -19), CH'D MATERIAL WAS 4140/4142 Q&T IS 4140/4142, ADDED HEAT TREAT RC 28-34.	4/14/2017	RJC	JAG



SECTION A-A

(-15)

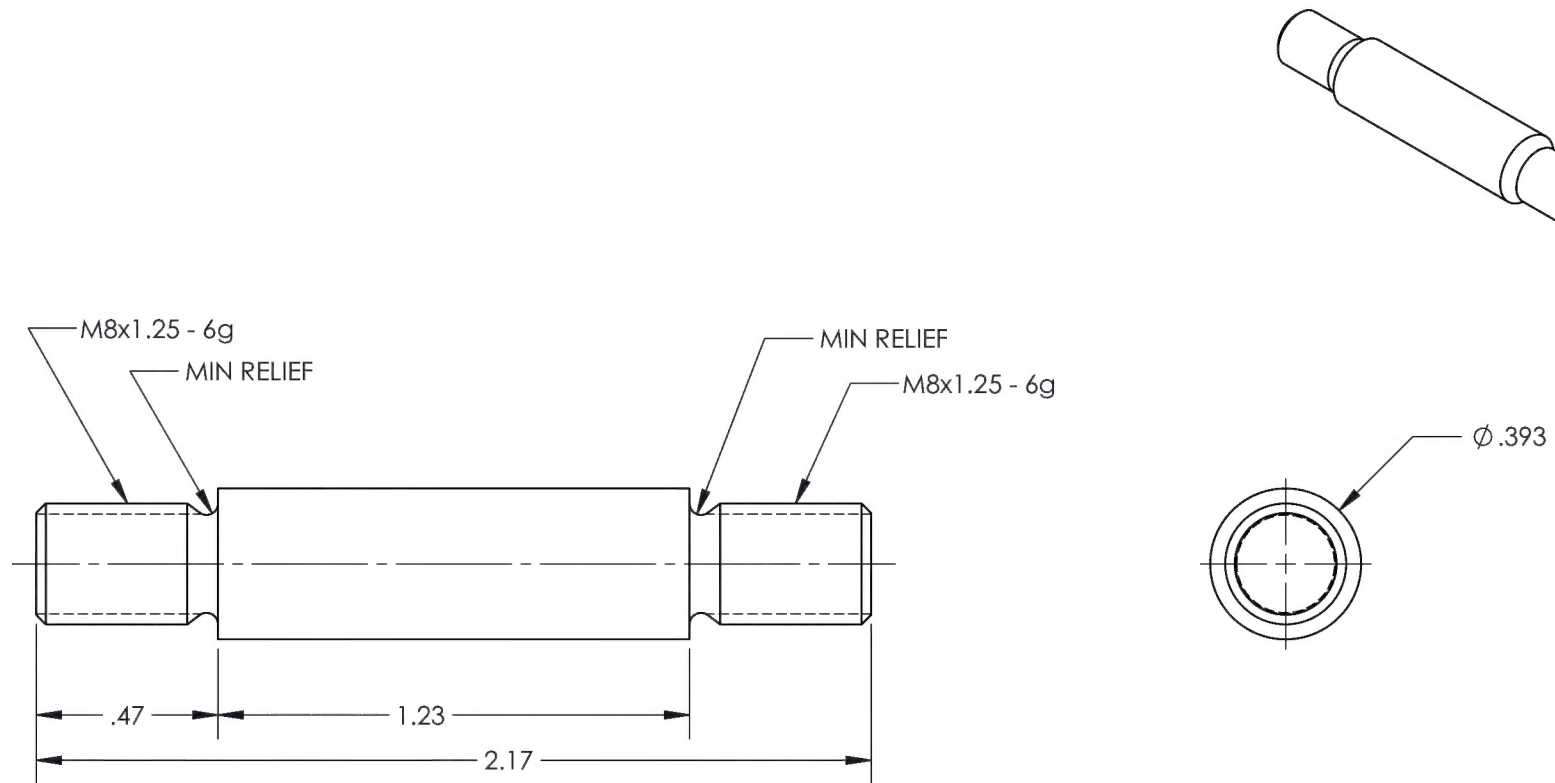
LOCK SCREW WRENCH HEAD

NOTE:
TIMING OF FEATURES NOT CRITICAL.

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-15	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 5/12/2016	USED ON MODEL
SHEET 9 OF 14	H175

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



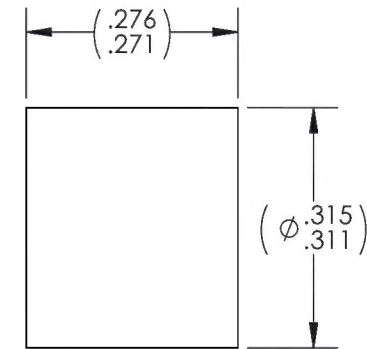
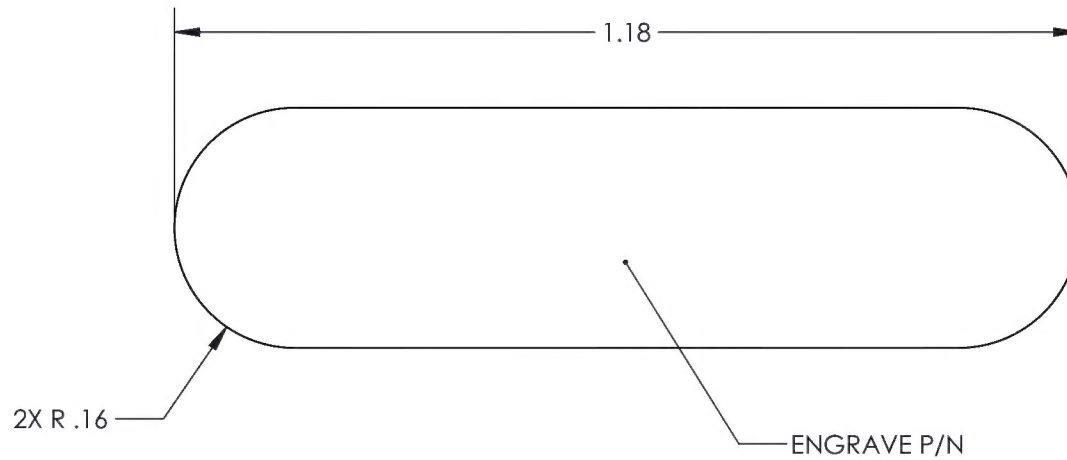
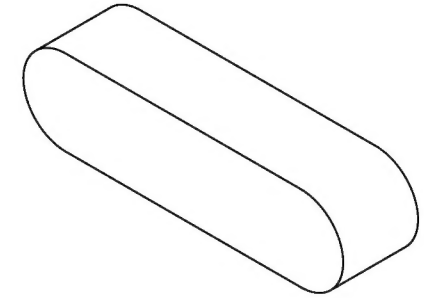
(-17)

THREADED ROD

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-17	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 5/12/2016	USED ON MODEL
SHEET 10 OF 14	H175

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-19 CH'D FINISH WAS QMSI-6.2.2 REV D IS QMSI-6.2.2, B.O. REV D.	4/14/2017	RJC	JAG

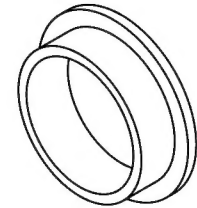
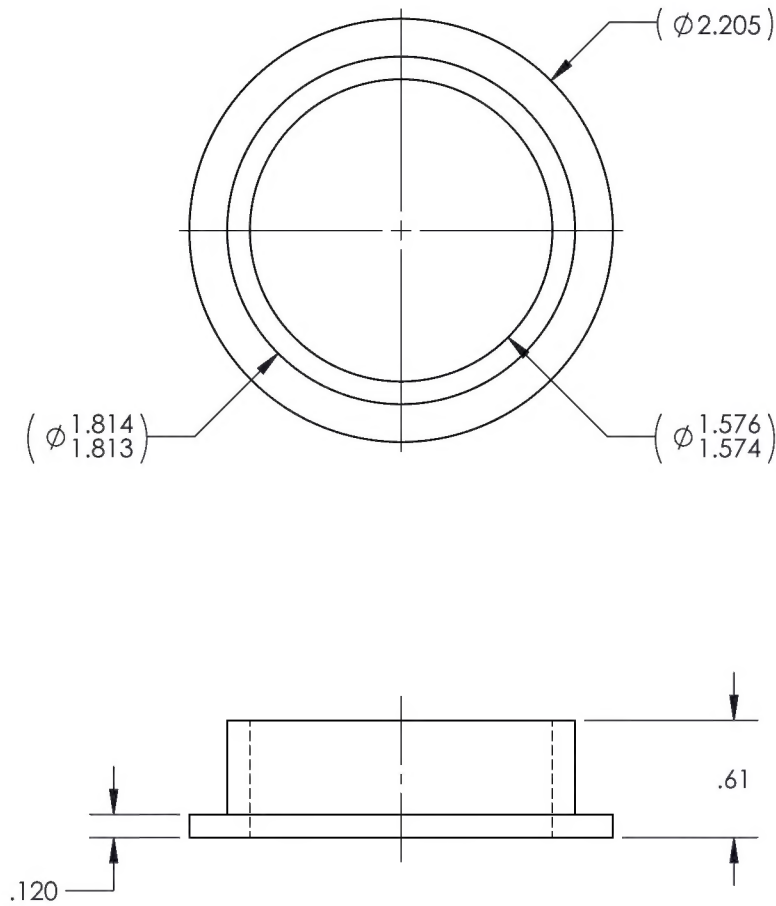


DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-19	REV 2
MAT'L STEEL HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 4:1	DATE 5/12/2016
SHEET 11 OF 14	

(-19)
KEY

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



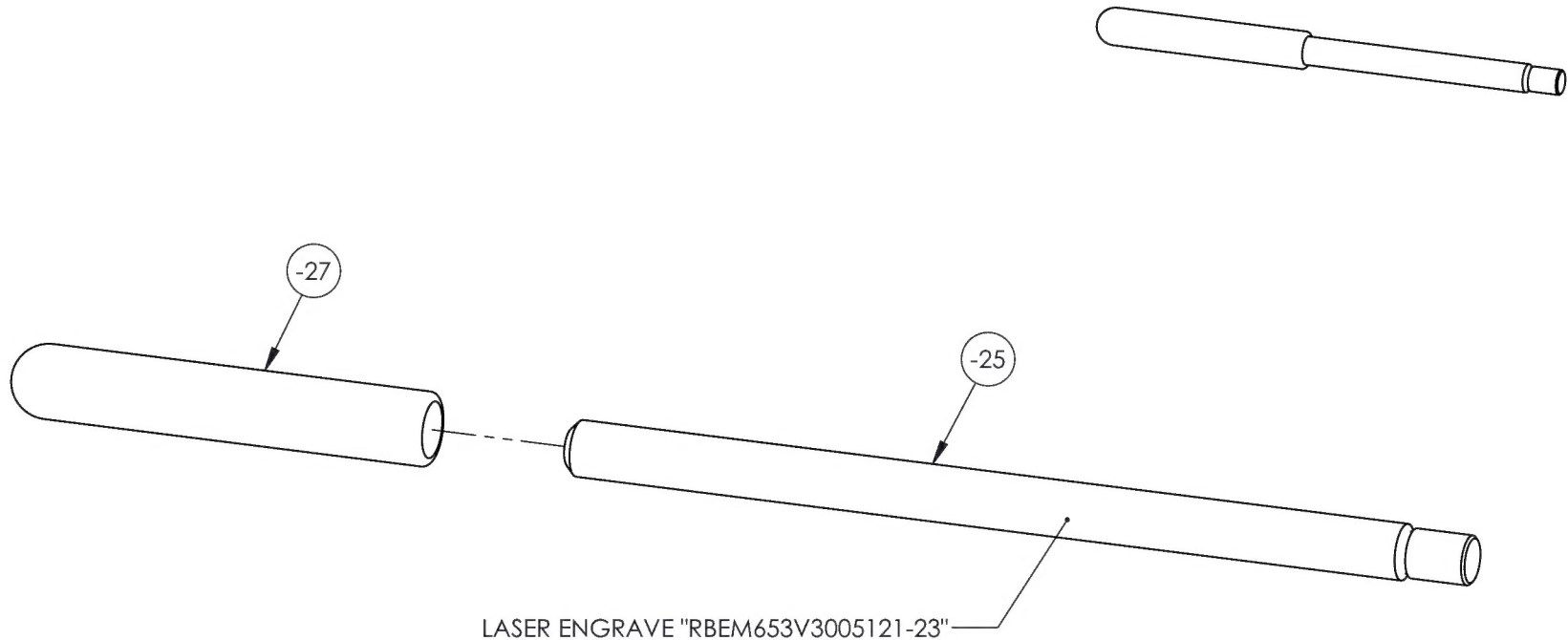
(-21)

FLANGED SLEEVE BEARING

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-21	REV 2
MAT'L SAE 660	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 5/12/2016
	SHEET 12 OF 14

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-23 CH'D ENGRAVE NOTE WAS INK STAMP "RBEM653V3005121-23" IS LASER ENGRAVE "RBEM653V3005121-23".	4/14/2017	RJC	JAG

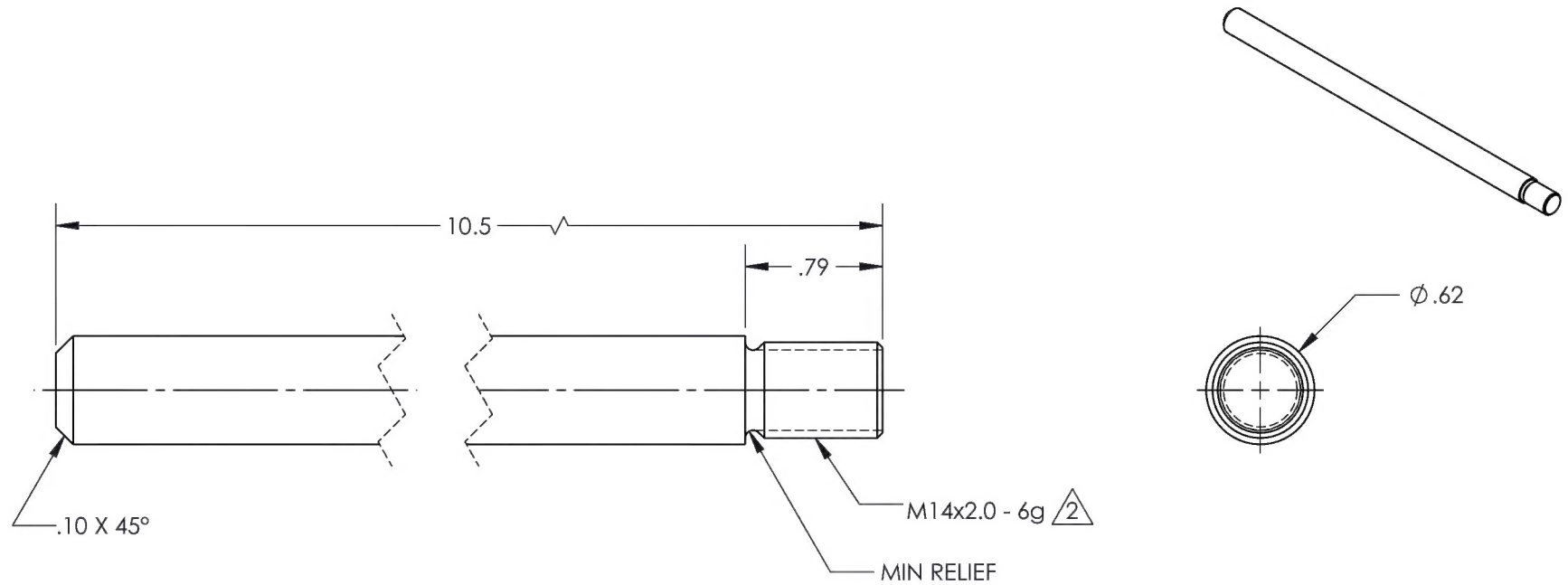


(-23)
HANDLE ASSEMBLY

DART AEROSPACE	
TITLE LABOR SAVING WRENCH	
DWG NO. RBEM653V3005121-23	REV 2
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:2	DATE 5/12/2016
SHEET 13 OF 14	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0006	-25 CH'D DIM WAS Ø.63 IS Ø.62.	4/14/2017	RJC	JAG



NOTES:

1. DUAL FINISH:

1ST: ZINC PLATE, ASTM B633 TYPE I SC2.

2ND: POWDER COAT YELLOW, FED #13538.

2 NO POWDER COAT THIS SURFACE.



TITLE		LABOR SAVING WRENCH	
DWG NO.		RBEM653V3005121-25	
REV		2	
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE NOTE 1		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY: DUERFELDT		.X ± .1 SURFACES = 125	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 5/12/2016		USED ON MODEL	
SHEET 14 OF 14		H175	

(-25)

HANDLE